

Work Order ID 84255

84255

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Tuesday, May 08, 2012 1:24:14 PM

Item ID: D4417-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly
 Start Date: 5/8/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 5/15/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: *WVF* Date: *12-05-08* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4417	B								
100		0.00							
100	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut D2622 to 106"AS PER DWG								
	2-DRILL HOLES USING DT9765								
	3-CUT ENDS AT 45 DEG AS PER DWG								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

8/12/04/12 / RL

Ac
12.05-08

RL
12.05.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Step Assembly

Stop ***NS2***

Start Date: 5/8/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/15/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

2 12-6-12

140

QC7-Inspect Chemical Conversion Coat

0.00

140

QC

Memo

0.00

Quality Control

DP 12-6-19

150

Weld per dwg A/R Aluminum rod Batch: 120854 0.00

150

Large Fab

Large Fab

Memo

0.00

Large Fab

1-SWAGE TUBES AS PER DWG

2-Weld cap per dwg D4417

3-grind flush

DP 12-6-19

2 0 12-06-20

2 0 Ae 12.06.25

W/O:		WORK ORDER CHANGES					
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 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <u>121613</u> HandFinishing Memo	0.00 0.00				2	0	2P	12/06/27
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				2 x	0	11	11/06/28
210 *210* Packaging Packaging	Identify as per dwg & Stock Location: <u>D4417-011 B966416</u> Memo	0.00 0.00				2	0	12	12-8-28

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NS1

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Stop

NS2

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Cust Item ID:

Required Date: 5/15/2012 Req'd Qty: 2.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

CK 12/14/28

MF
12-08-28

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 08, 2012 1:24:14 PM

Page 1

Work Order ID: 84255

Parent Item: D4417-041

Parent Item Name: Step Assembly

Start Date: 5/8/2012

Required Date: 5/15/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC
REVB. DD VERF:JLM

IPP REV:B 11.08.17 PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C Step Extrusion		Manufactured	No			100	Each	45.6100	1	2		12.05.08	

Location	Loc Qty	Loc Code
HALL	16.37	
46910	2	
64409	6	
66970	7.7	
68293	0.25	
72131	0.42	
WA	19.88	
81507	19.88	
WA013	9.36	
75781	2	
77612	7.36	

D2734
Step End Plate

Manufactured No 150 Each 29.0000

2 4 12.06.20

Location	Loc Qty	Loc Code
WA 383322	29	
76985	13	
80682	16	

D4425-1
Step Spacer

Manufactured No 150 Each 2.0000

2 4 12.6.18

Location	Loc Qty	Loc Code
WA003 385917=2	2	
73194	2	

2 2 12.6.19

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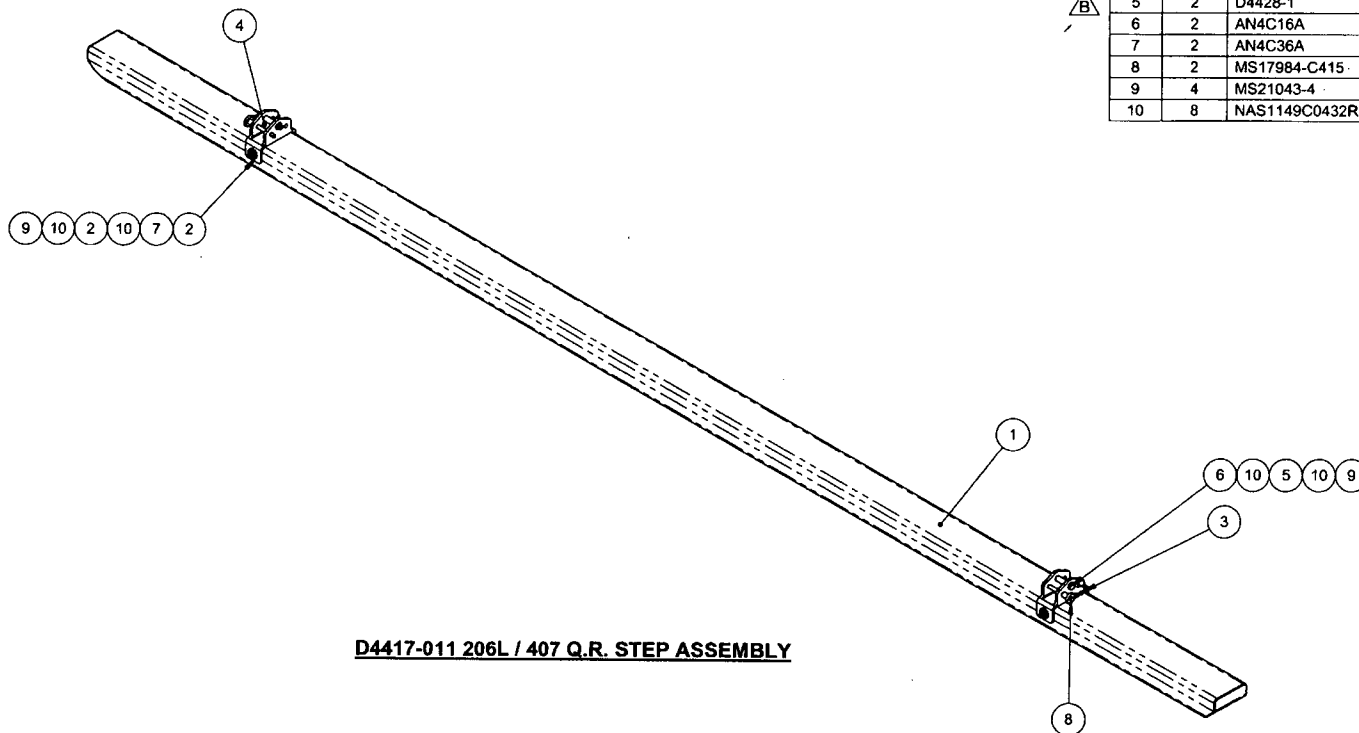
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



D4417-011 206L / 407 Q.R. STEP ASSEMBLY

ITEM	QTY -011	P/N	DESCRIPTION
	X	D4417-011	206L / 407 Q.R. STEP ASSEMBLY
1	1	D4417-041	STEP ASSEMBLY
2	4	D2570	BUSHING
3	2	D2690-6	LANYARD ASSEMBLY
4	2	D4418-1	STEP LUG
5	2	D4428-1	BUSHING
6	2	AN4C16A	BOLT
7	2	AN4C36A	BOLT
8	2	MS17984-C415	QUICK RELEASE PIN (BLBS-020)
9	4	MS21043-4	NUT
10	8	NAS1149C0432R	WASHER

#84255

RELEASED
2011-08-02

B	REPLACED NAS43DD4-64 SPACER WITH ITEM 5. ITEM 3 WAS -5.	AJS	11.07.28
A	NEW ISSUE	AJS	11.07.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4417	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		206L / 407 Q.R. STEP ASSEMBLY	NTS
DATE	11.07.28	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

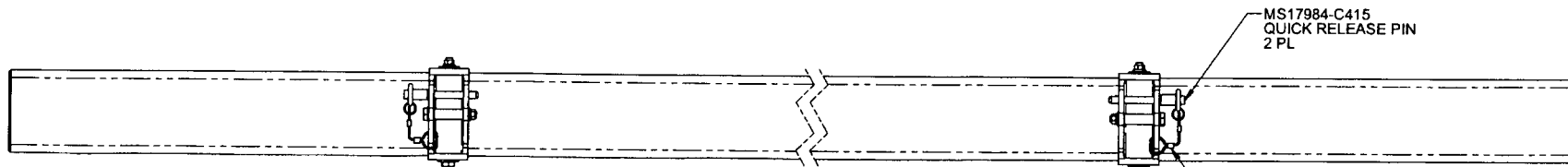
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8 7 6 5 4 3 2 1



AN4C36A BOLT
NAS1149C0432R WASHER, 2X
D2570 BUSHING, 2X
MS21043-4 NUT
2 PL

MS17984-C415
QUICK RELEASE PIN
2 PL

D2690-6
LANYARD ASSEMBLY
2 PL

AN4C16A BOLT
NAS1149C0432R WASHER, 2X
D4428-1 BUSHING
MS21043-4 NUT
2 PL

D4418-1
STEP LUG
2 PL

D4417-041
STEP ASSEMBLY

#84235



6

D4417-011 206L / 407 Q.R. STEP ASSEMBLY

RELEASED
2011-08-02
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4417-011" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 8.75 lbs

DESIGN	AJS	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D4417	REV. B
MFG. APPR.			SHEET 2 OF 4
APPROVED		TITLE 206L / 407 Q.R. STEP ASSEMBLY	SCALE NTS
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DATE	11.07.28		

8 7 6 5 4 3 2 1

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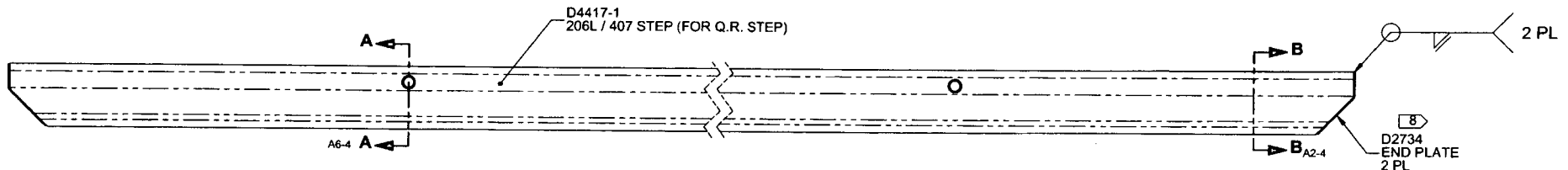
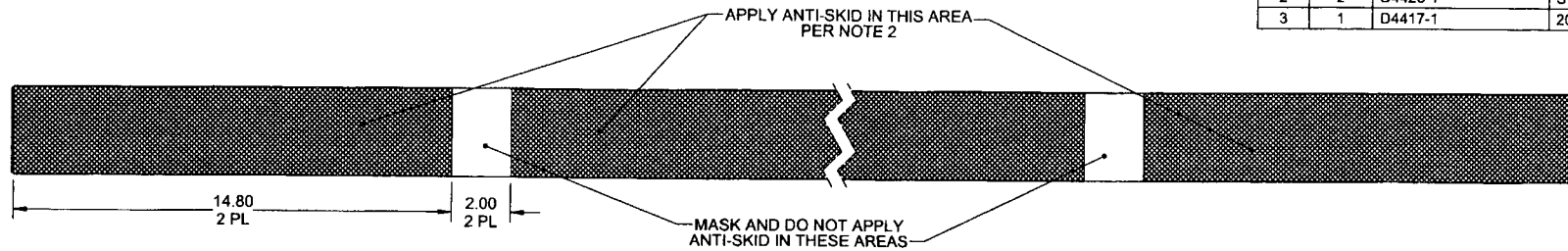
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

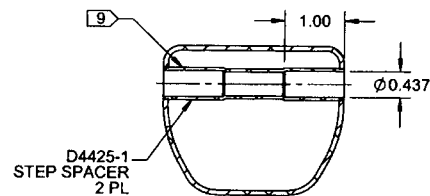
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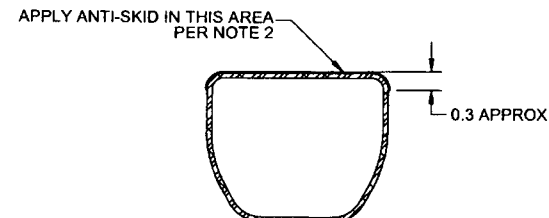
ITEM	QTY	P/N	DESCRIPTION
	X	D4417-041	STEP ASSEMBLY
1	2	D2734	END PLATE
2	2	D4425-1	STEP SPACER
3	1	D4417-1	206L / 407 STEP (FOR Q.R. STEP)



D4417-041 STEP ASSEMBLY



SECTION A-A C7-4
SCALE 2X



SECTION B-B C2-4
SCALE 2X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.00 lbs
- 8) APPLY ALODINE AFTER WELDING ON THE D2734 END CAPS AND PRIOR TO INSTALLATION OF D4425-1 STEP SPACERS.
- 9) SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AJS	DRAWING NO. D4417	REV. B
MFG. APPR.	RE		SHEET 3 OF 4
APPROVED	MR	TITLE 206L / 407 Q.R. STEP ASSEMBLY	SCALE NTS
DE APPR.	MR		
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RELEASED
2011-08-02
MD

#84255

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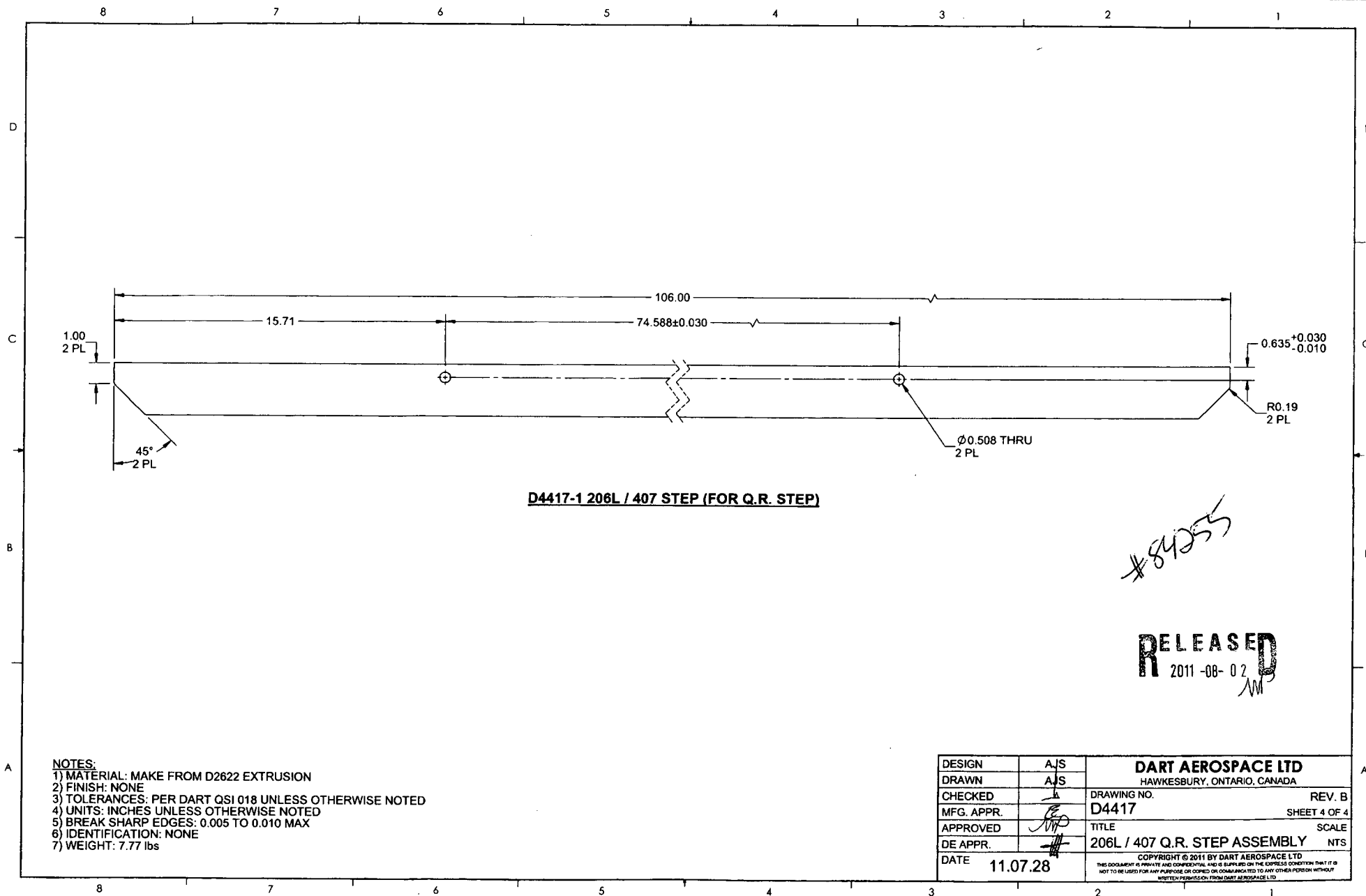
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NOTE: Date & initial all entries



#84255

RELEASED
2011-08-02

- NOTES:**
- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 7.77 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4417	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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